

Work Order ID 57810

April 15, 2010 3:01:07 PM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 15/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-14-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2989

Rev D

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: *M111679*

PL 10.04.28

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

D 10.04.29

Work Order ID 57810

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Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	15/04/2010	Start Qty:	1.00			
Required Date:	23/04/2010	Req'd Qty:	1.00			
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	<p>1- Plug holes prior to powder coating</p> <p>2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989</p> <p>1ST COAT</p> <p>START TIME: 8:15AM</p> <p>OVEN TEMPERATURE: 400°</p> <p>FINISH TIME: 8:45AM</p> <p>***** 2nd coat if necessary *****</p> <p>2ND COAT</p> <p>START TIME: 9:00AM</p> <p>OVEN TEMPERATURE: 400°</p> <p>FINISH TIME: 9:30AM</p>								

1114207

→ 10/05/05

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Page 3

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 15/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

①

BR 10-5-3.

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

W6 57643
Memo

0.00

Packaging

①

BR 10-5-3.

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04

BR 10-5-04
①

Picklist Print

Page 1

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Work Order ID: 57810

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 15/04/2010

Required Date: 23/04/2010

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 7.0000 1.0000



Rib

Pl 10.04.22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

57182

7

7

①

Pl 10.04.22

D2989-3

Manufactured No

100 Each 2.0000 1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

57420

2

2

①

Pl 10.04.22

D2989-4

Manufactured No

100 Each 2.0000 1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

57421

2

2

①

Picklist Print

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Page 2

Work Order ID: 57810

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 15/04/2010

Required Date: 23/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-5



Manufactured No

100 Each 6.0000 2.0000

Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6

57419

2

57596

4

Manufactured No

100 Each 2.0000 2.0000

D3182-1



Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

2

57341

2

Manufactured No

100 Each 18.0000 2.0000

D3442-3



Shim

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

18

53137

4

56204

14

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 57810

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 15/04/2010

Required Date: 23/04/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3827-041 Manufactured No 100 Each 2.0000 1.0000
 Rib Assembly (Inboard)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

55982

2

2

B57219 → ①

✓ D3832-5 Manufactured No 100 Each 5.0000 1.0000
 Mesh (Lid)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

56084

57603

5

2

3

①

✓ D3833-5 Manufactured No 100 Each 15.0000 2.0000
 Mesh (Lid End)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

51305

53722

15

2

13

②

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Page 3

Picklist Print

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Page 4

Work Order ID: 57810



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 15/04/2010

Required Date: 23/04/2010

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3838-041

Manufactured No

100

Each

0.0000

1.0000



Rib Assembly (Basket Lid, LH)

✓ D3838-042

Manufactured No

100

Each

0.0000

1.0000



Rib Assembly (Basket Lid, RH)

357422 → ① Plc 10-0427

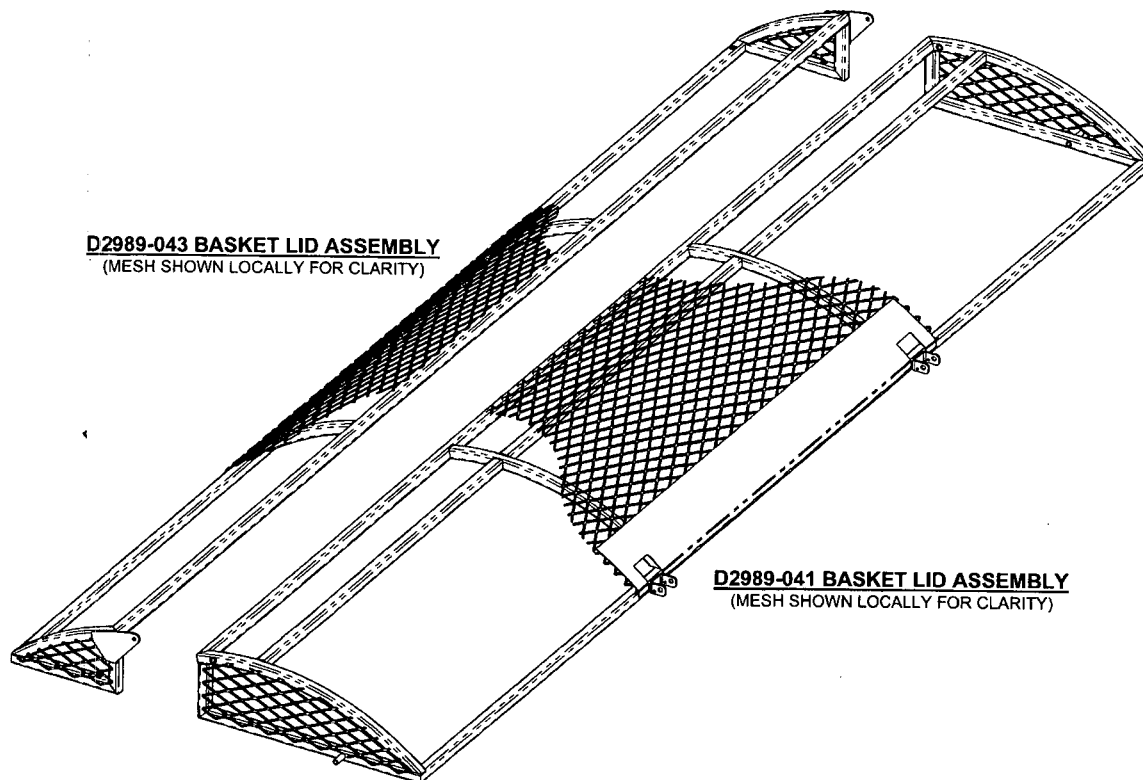
357423 → ① Plc 10-0427

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Shop Packet Print

Page 4

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/15

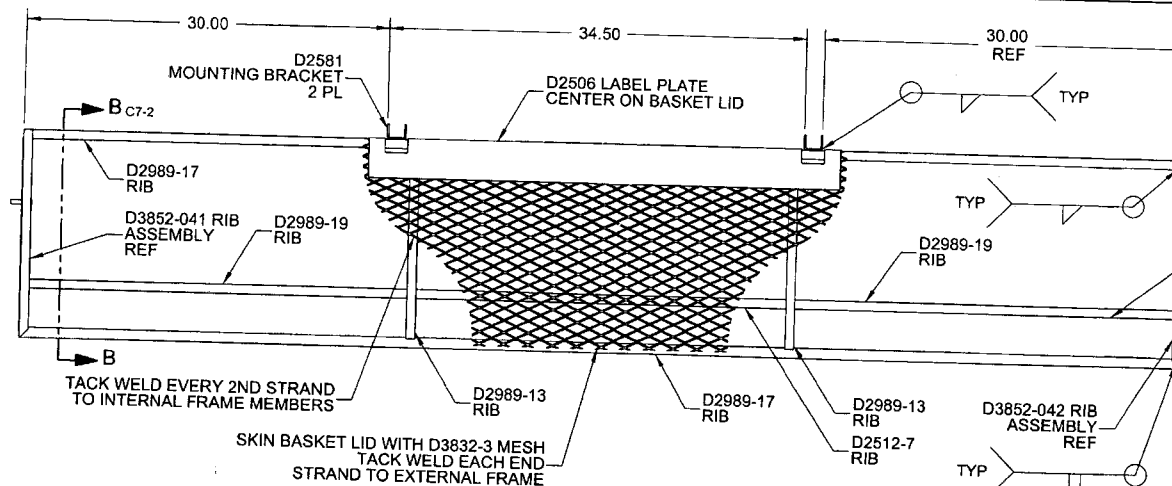
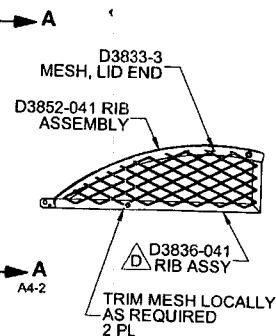
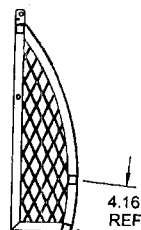
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 57810
08/10-4-15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

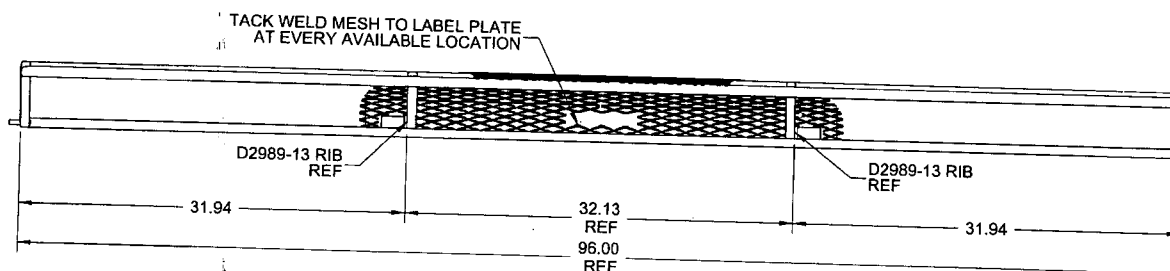
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N 03-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.05.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS		
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	DS	D2989	SHEET 1 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

SECTION B-B

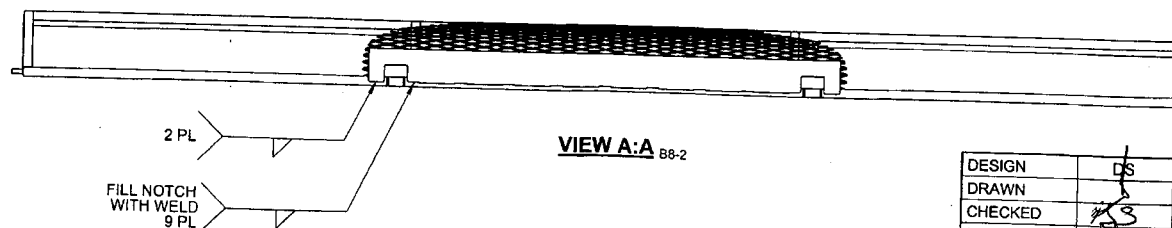
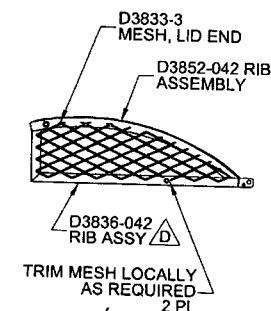


TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID PAINT THIS SECTION



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



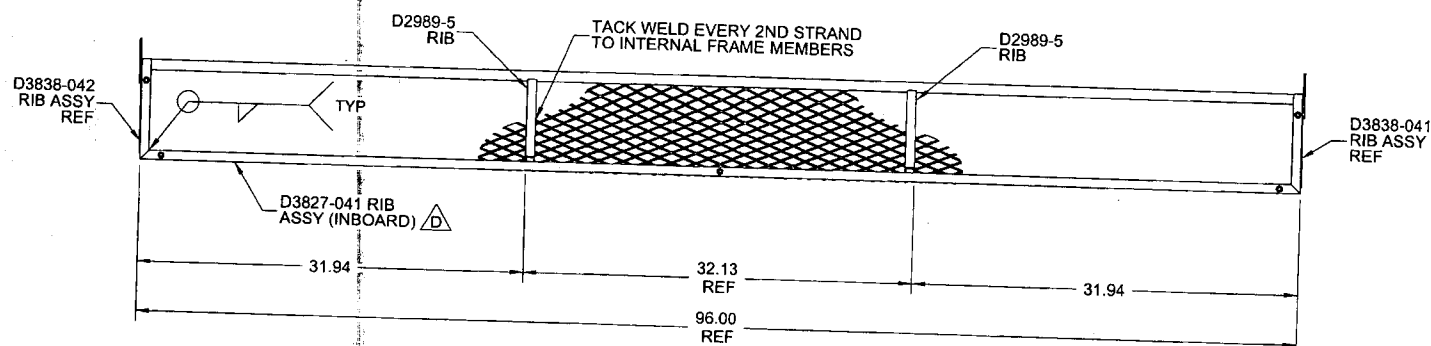
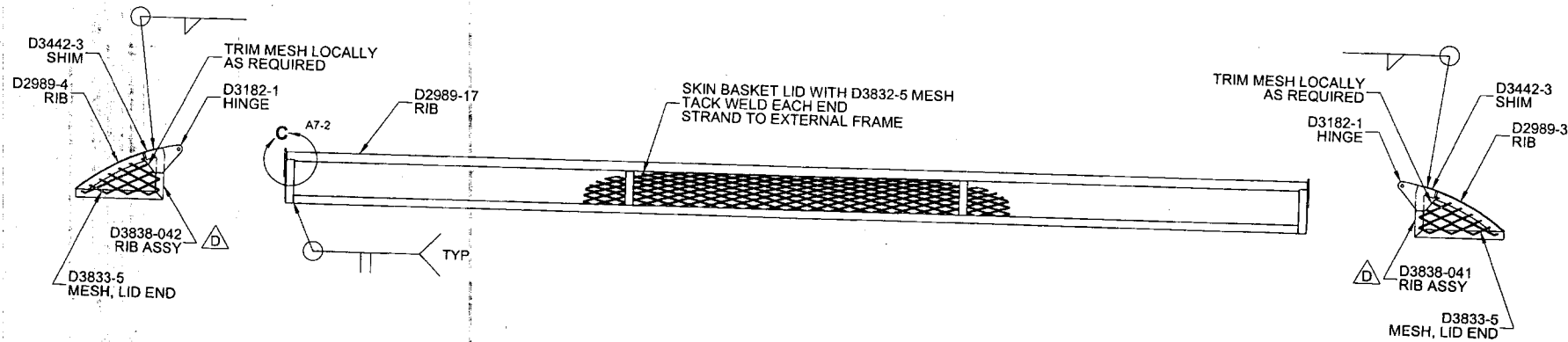
VIEW A-A B8-2

u/o 57810

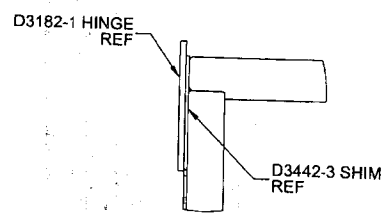
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08/11/18/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. I
MFG. APPR.	JD	D2989	SHEET 2 OF 5
APPROVED	V. 1/14	TITLE	SCALE
DE APPR.	#	BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	
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8 7 6 5 4 3 2 1



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



DETAIL C
TYP, SCALE 4X

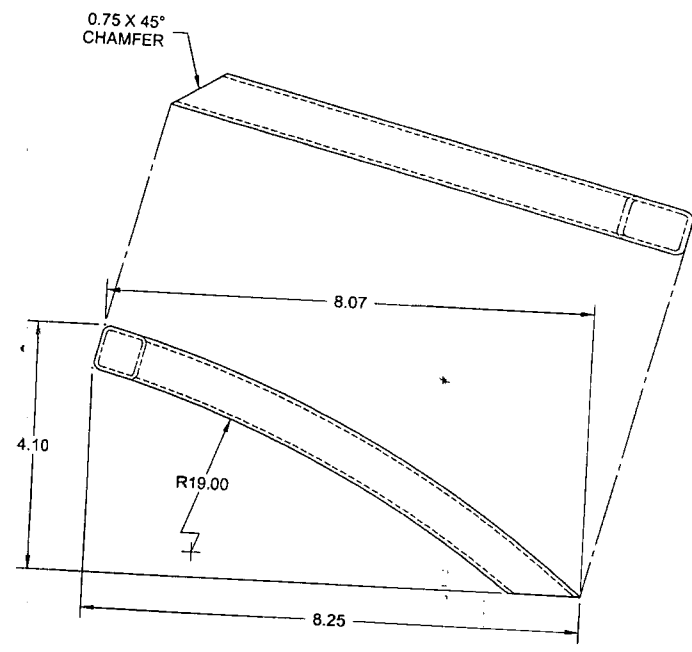
w/o 57810

RELEASED
08/11/18

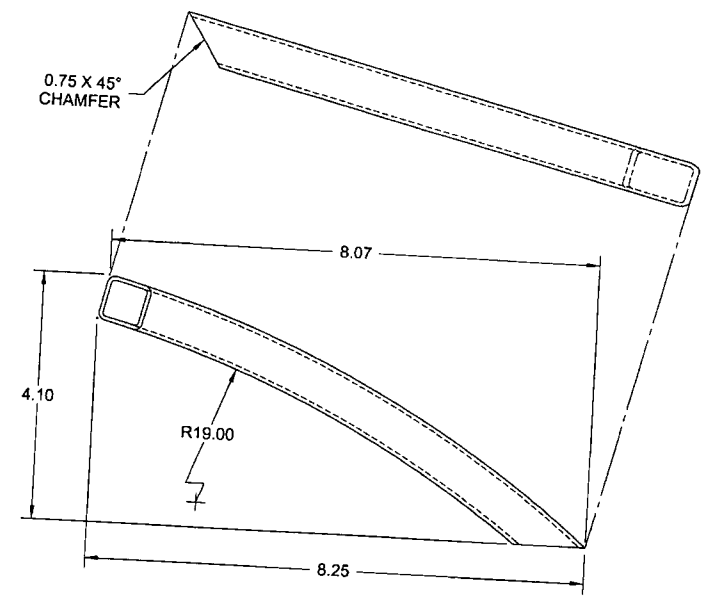
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D2989	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D2989-3 RIB

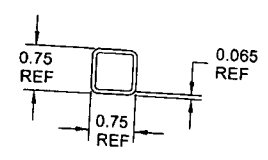


D2989-4 RIB

w/o 57810

RELEASED
08/11/18 NW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



TYPICAL SECTION VIEW

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

